

# Work Order ID 61026

August 4, 2010 9:58:51 AM



Page 1

Item ID: D412-698-032

Accept

Revision ID:

Item Name: Cabin Door Roller, RH

Start Date: 8/04/10 Start Qty: 1.00

Required Date: 8/11/10 Req'd Qty: 1.00

Reference:

Approvals: Process Plan: *BL*

Date: 10-8-04

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

IIN D412-698

Rev E

100



DC

Document Control

DOCUMENT CONTROL

0.00

Memo

0.00

Photocopy bluefile & type labels per PPP D412-698-032

CHG001

*8/10/08/09*

*BL 10-8-04*

110



Packaging

Packaging

Pick Kit

0.00

Memo

0.00

*10/8/09 SL 10*

120



QC

Quality Control

QC4- 100% Inspect kits for completeness

0.00

Memo

0.00

*8/10/08/09*

*(2)*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Item ID: D412-698-032

Accept



Setup

Start



Revision ID:

Stop



Item Name: Cabin Door Roller, RH

Start Date: 8/04/10 Start Qty: 1.00



Cust Item ID:

Required Date: 8/11/10 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130



Packaging

Packaging

0.00

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D412-698-031  
Location: 62 PPP Rev: A

10/8/09 sl P

140



QC

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

Quality Control

10/08/09 J

MF 10-8-9

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 61026

Parent Item: D412-698-032

Parent Item Name: Cabin Door Roller, RH

Start Date: 8/04/10

Required Date: 8/11/10

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A New Issue 08.07.03 EC verified by:LL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3121-144 Bracket Assembly		Manufactured	No			120	Each	6.0000	1	1		10/8/9sf	
				<u>Location</u>				<u>Loc Qty</u>	<u>Loc Code</u>				
				ST235A				6					
				58768				2					
				60292				4					
D3137-043 Bracket Assembly		Manufactured	No			120	Each	7.0000	1	1		10/8/9sf	
				<u>Location</u>				<u>Loc Qty</u>	<u>Loc Code</u>				
				ST235B				7					
				42192				1					
				59916				6					
D3183-044 Bracket Assembly		Manufactured	No			120	Each	5.0000	1	1		10/8/9sf	
				<u>Location</u>				<u>Loc Qty</u>	<u>Loc Code</u>				
				ST236				5					
				54760				1					
				60293				4					
D3202-3 Cover		Manufactured	No			120	Each	9.0000	1	1		10/8/9sf	
				<u>Location</u>				<u>Loc Qty</u>	<u>Loc Code</u>				
				ST241A				9					
				52284				9					

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 61026

Parent Item: D412-698-032

Parent Item Name: Cabin Door Roller, RH

Start Date: 8/04/10

Required Date: 8/11/10

Start Qty: 1.00

Required Qty: 1.00

D3674-041

Manufactured No

120

Each

13.0000

3

3



BRACKET ASSEMBLY



10/8/9 sf

Location

Loc Qty

Loc Code

ST236A

13

42514

13

D3675-1

Manufactured No

120

Each

37.0000

9

9



SLIDING DOOR BRACKET



10/8/9 sf (120)

Location

Loc Qty

Loc Code

ST236A

37

52168

37

9

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Shop Packet Print

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W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**8.0 PARTS LIST - CABIN DOOR MODIFICATION KITS**

(FOR AIRCRAFT EQUIPPED WITH P/N 412-030-300-XXX COMPOSITE DOORS)

Qty -019	Qty -021	Qty -031	Qty -032	Qty -033	Qty -035	Part Number	Description
X						D412-698-019	BEARING OVERHAUL KIT
	X					D412-698-021	REPLACEMENT SHIM KIT
		X				D412-698-031	CABIN DOOR ROLLER KIT, LH
			X			D412-698-032	CABIN DOOR ROLLER KIT, RH
				X		D412-698-033	REPLACEMENT DOOR TRACK KIT
					X	D412-698-035	DOOR HANDLE KIT
7						D3121-21	BOLT
5						D3121-241	BEARING ASSEMBLY
1						D3137-3	GUIDE
1						D3137-5	WASHER
2						D3183-045	BEARING ASSEMBLY
	3					D3238-1	SHIM
	1					D3238-3	SHIM
	2					D3238-5	SHIM
	6					D3238-11	SHIM
	2					D3238-13	SHIM
	4					D3238-15	SHIM
		1				D3121-143	BRACKET ASSEMBLY
			1			D3121-144	BRACKET ASSEMBLY
		1	1			D3137-043	BRACKET ASSEMBLY
		1				D3183-043	BRACKET ASSEMBLY
			1			D3183-044	BRACKET ASSEMBLY
		1	1	1		D3202-3	COVER
		3	3			D3674-041	BRACKET ASSEMBLY
		9	9	9		D3675-1	BRACKET
					2	D3779-041	HANDLE ASSEMBLY
					2	D3779-3	PLATE
					2	D3779-043	HANDLE ASSEMBLY
					12	AN525-832R8	SCREW
					12	AN960JD10L	WASHER
					12	MS21042L3	NUT
					12	MS24694-S58	SCREW
1						MS24694-S101	SCREW

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Revision: E  
 Date: 08.05.01